CURRENT CHG LETTER	REVISIONS						
SHEET 2 Δ	ZONE	LTR	DESCRIPTION	DATE	APPROVED	DR	CK	ENGR APPROVAL
		A	(1) ADDED ITEM NO 14 (2) ADDED 1.75/1.25 DIM	8/11/83	[illegible]			X
80-1 81-1		B	(1) ADDED ITEM NO 14 (2) ADDED 1.75/1.25 DIM	8/11/83	[illegible]			/

4 HOLES EQ SP THRU
FOR ASSY WITH
(A1 3.37 DIA)

.375-24UNF-3A

.03 X 45°

3.25

VIEW A
5 X SIZE

- B - (REF)

R.005 MAX
3 PL

HDN FOR
THIS DIST

1.00

.280
.270

A

.175
.170

.031
.029

Ø.380
.370
- C -

.002 B C

.250
.246

Ø.231
.229

.001 C M
- B -

(4) 1 REQD SAE 4340
HDN Rc 40-44 AS SHOWN

Ø.6820-.6908 THRU
CSK 85°-95° TO Ø.760-.800
.750-16UNF-3B THRU
.001 D
- E -

60°

KNURL

Ø.264-.273
.50 DP 3 HOLES
EQL SP

Ø2.50

63

.50

.250

.06 X 45°
2 PL

.002
- D -

Ø.1960-.2067 THRU TO BORE
CSK 85°-95° TO Ø.260-.300
.250-20UNC-3B THRU - 3PL
Ø.010 M D E M

(7) 1 REQD SAE 1010-1025

Ø.217-.225 THRU
CBORE Ø.342-.351 X .38 DP
2 HOLES
Ø.010 M F G

.002
- F -

.750

.250

.440

1.00

2.00

1.240

.002 F
- G -

.06 X 45°
2 PL

(1) 1 REQD SAE 1010-1025

VISE JAWS
(REF)

P.F. AT ASSY

1 2 3 4 5 6 7 8 9 10 11 12 13 14

METAL STAMP
PER NOTE 1

(8₁) (8₂)

1.75
1.25

RING, SEAL
(REF)

BRG HSG, FRT
(REF)

Ø.180-.186 THRU
4 HOLES EQ SPD.
Ø.005 M H J M

Ø2.000

Ø.6820-.6908 THRU
CSK 85°-95° TO Ø.760-.800
.750-16UNF-3B THRU
Ø.005 M H J M

Ø2.374
2.373

Ø1.50

Ø.858
.854

- J -

R.12

.50

R.25

63

.200

// .005 H

- H -

.060 X 45°

15°

4.330

4.830

R.062

R.020 MAX

.080

Ø.654
.651
Ø.005 M H J M

Ø.972
.968

Ø1.136
1.134

.002 H J

(8) 1 REQ'D SAE 4340
HRN Rc 42-46

Ø.12 THRU
8 HOLES

R.03

4.00

30°
2 PL

A2

.030
2 PL

.060
8 PL EQL SP

SCALE: 10/1

NOTES:

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH THE 3 OR 4 HIGH FIGURES THE FOLLOWING: THE LETTER "A" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER OF ALLISON GAS TURBINE DIVISION, G.M.C. OR TRADEMARK.

2. BLACK OXIDE ITEMS 1, 4, 5, 6, 7, 8, 10 AND 11 PER AMS 2485.

14	1	O-RING	02697281 N674-70 OR EQUIV	PARKER-HANNIFIN		1
13	3	CONE PT. SOC. SET SC.		.250-20UNC x .75LG	STEEL	1
12	1	RING-RETAINING	79136	S100-25	TRUARC	1
11	1	FOOT			STEEL	2
10	1	BODY			STEEL	2
9	4	BUTTON HD. CAP SC.		.64-36UNF x .50LG	STEEL	1
8	1	COLLET			STEEL	1
7	1	KNOB-HAND			STEEL	1
6	1	EXPANDER			STEEL	2
5	1	KNOB-HAND			STEEL	2
4	1	ROD-PUSH			STEEL	1
3	1	PIN-DOWEL		.187 X 1 LG	STEEL	1
2	2	SOC. HD. CAP SC.		.190-24UNC X 1 LG	STEEL	1
1	1	BLOCK			STEEL	1
ITEM NO.	NO. REQ'D	NOMENCLATURE OR DESCRIPTION	CODE IDENT	PART OR IDENTIFYING NO.	MATERIAL OR NOTES	SH. NO.

FOR PART IDENTIFICATION ITEM NUMBERS (AS EXAMPLE), DESIGN NUMBERS OF THIS BASIC DRAWING ARE LEFT WHERE A "0" WERE SPECIFIED IN THE PART IDENTIFYING NUMBER COLUMN

These tool drawings are furnished in accord with the terms of the Allison Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Allison Gas Turbine Division, G.M.C.

FILE COPY

BREAK SHARP EDGES .020 UOS

APPLICATION: SEE SEPARATE PARTS LIST

UNLESS OTHERWISE SPECIFIED TOLERANCE TRUE POSITION CALLOUTS MAY BE USED SEPARATELY REGARDLESS OF DATUM REFERENCE

UNLESS OTHERWISE SPECIFIED
TOL. ON ANGLES ± 1°
TOL. ON 2 PLACE DECIMALS ±.02
TOL. ON 3 PLACE DECIMALS ±.010

MATL: SEE ITEM

HEAT TREAT AND HARDNESS: SEE ITEM

SURFACE TREAT: SEE NOTE

DRAWING DATE	8-1-75	
DRAFTSMAN	CHEAPE CHIEF	
CHECKER	TECH LIFT	
APPROVED		
METALLURGY		
ENGR 1	J.C. FARRELL	
ENGR 2	GRISWOLD	
FINAL	R.A. LOTZ	
WELD OR BRAZE		
INSPECTION		

UOS ALL DIMENSIONS ARE IN INCHES

THIRD ANGLE PROJECTION

	SAE 1010-1025
	SAE 4340
	AMS-2485
LOCAL SPECS. (REF)	
DRAWING PRACTICE	
SURFACE TEXTURE	
SCREW THREADS	
GENERAL SPECIFICATIONS	SPEC. SUMMARY

Allison
GAS TURBINE DIVISION
General Motors Corporation
Indianapolis, Indiana

TITLE: PULLER-COMP. FRONT BEARING RING SEAL

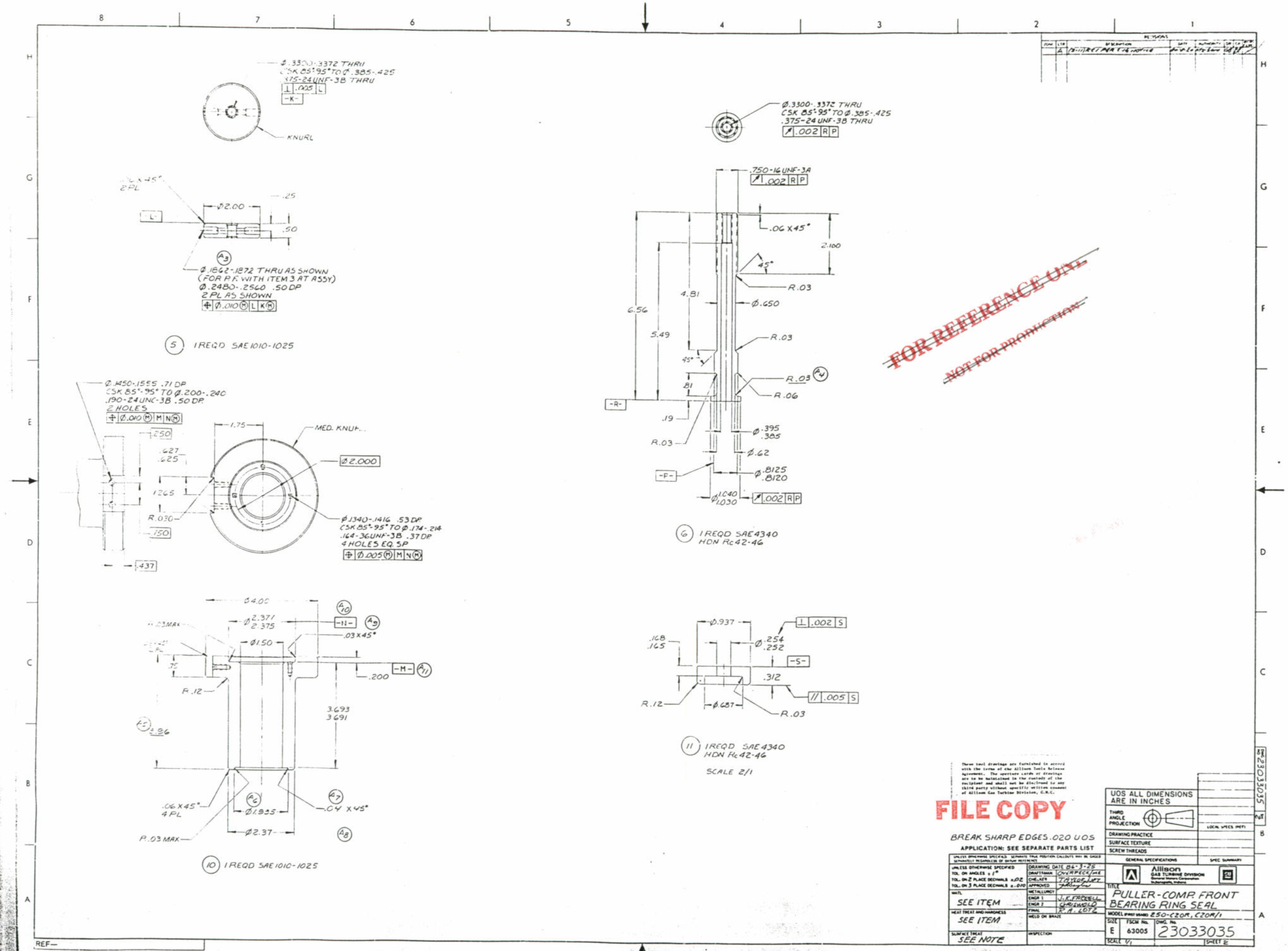
MODEL (FIRST USAGE): 250-C20R, C20R/1

SIZE	FSCM No.	DWG. No.
E	63005	23033035

SCALE 1/1 0.5 SHEET 1 OF 2

23033035 T

REF-T159063



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BREAK SHARP EDGES .020 UOS
APPLICATION: SEE SEPARATE PARTS LIST

UNLESS OTHERWISE SPECIFIED: SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY REGARDLESS OF DATUM REFERENCE

UNLESS OTHERWISE SPECIFIED TOL. ON ANGLES ± 1° TOL. ON 2 PLACE DECIMALS ±.02 TOL. ON 3 PLACE DECIMALS ±.010	DRAWING DATE 86-3-25	
	DRAFTSMAN	OVERPECK/ME
	CHECKER	TAYLOR/JRT
	APPROVED	
MATL SEE ITEM	METALLURGY	
	ENGR 1	J.K. FARRELL
	ENGR 2	GRISWOLD
HEAT TREAT AND HARDNESS SEE ITEM	FINAL	R.A. LOTZ
	WELD ON BRAZE	
SURFACE TREAT SEE NOTE	INSPECTION	

UOS ALL DIMENSIONS ARE IN INCHES
THIRD ANGLE PROJECTION
LOCAL SPECS (REF)
DRAWING PRACTICE
SURFACE TEXTURE
SCREW THREADS
GENERAL SPECIFICATIONS
SPEC SUMMARY

Allison GAS TURBINE DIVISION General Motors Corporation Indianapolis, Indiana

TITLE PULLER-COMP. FRONT BEARING RING SEAL

MODEL (FIRST USED) 250-C20R, C20R/1

SIZE E | FSCM No. 63005 | DWG. No. 23033035

SCALE 1/1 | SHEET 2

DWG NO 23033035

REF—